



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2665-1
Job Sheet 196972



Part No: D2665-1

Job Qty: 4 pcs ✓

Part Name: Saddle, LH Fwd Aft Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/26/19

Job Tracking No:

Due Date: 7/15/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	7/15/19	7/15/19	1.00	6.15	HAAS - 1		SBL 19/07/00
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	Conventional Mill - 1 - B4B	4 pcs	7/15/19	7/15/19	0.00	4.00	Conventional Mill - 1 - B4B		SBL 19/07/00
							Conventional Mill - 2 - B4B		
120	QC 2	4 pcs	7/15/19	7/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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Container No: S196289



Part: D2665-1

Job No: 196972

Serial No/Batch: S196289

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/06/19

Plex 6/26/19 10:03 AM Dart.Guerin.Kimberley

					QC 2 - 57	SBL 19/07/07
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
QC 8 - 32						
QC 8 - 33						
QC 8 - 35						
QC 8 - 39						
QC 8 - 4						
QC 8 - 44						
QC 8 - 45						
QC 8 - 49						
QC 8 - 58						
QC 8 - 8						
QC 8 - 9						
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
130 QC 8	4 pcs	7/15/19	0.00 0.00	QC 8 - 12	mk 19/07/08	
				QC 8 - 14		
				QC 8 - 17		
				QC 8 - 20		
				QC 8 - 25		
				QC 8 - 3		
				QC 8 - 32		
				QC 8 - 33		
				QC 8 - 35		
				QC 8 - 39		
				QC 8 - 4		
				QC 8 - 44		
				QC 8 - 45		
				QC 8 - 49		
				QC 8 - 58		
				QC 8 - 8		
				QC 8 - 9		
QC 8 - 68						
QC 8 - 67						
QC 8 - 1 (A)						
QC 8 - 47						
QC 8 - 40						
QC 8 - 52						
QC 8 - 23						
QC 8 - 57						
140 Handfinish - 1-1 Chemical-B4B	4 pcs	7/15/19	0.00 0.28	Handfinish - 1 - 1 - B4B	★ JUL 09 2019	
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
150 Powdercoat - 1 White Gl(A)-	4	7/15/19	0.00 0.20	Powdercoat - 1 - B4B	BL 14-79	
START: 2:10				OV.T: 330° FINISH 2:40	Plex 6/26/19 10:03 AM Dart.Guerin.Kimberley	

M175459

START. 2:10 O.V.T. 3:30 FINISH 2:40

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B4B	pcs				Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
160 QC 7	4 pcs	7/15/19	0.00 0.00		QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
170 Packaging 3-1 - Stock - B4B	4 pcs	7/15/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					→ Packaging 3 - 3 - B4B	O.R. Bin: 5T402
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	

DAS
81
9-89

JUL 10 2019

				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
180 QC 21 - SA	4 pcs	7/15/19	0.00 0.00	QC 21 - SA - 21	DAS		
				QC 21 - SA - 70	JUL 16 2019 70		
				QC 21 - SA - 53	9-89		
Part Op 100 - HAAS CNC Vertical Machine Program batch number. 1- Inspect part number and batch number are programmed Descriptions: correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 110 - Manufacture as per dwg - Machine Keyway and inspect per attached dimension sheet 120 - QC2- Inspect parts off machine FAI/FAIB 130 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC 7 - Inspect Chemical conversion coat 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-HAAS 4 Axis	S175 541			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-HAAS 4 Axis	D6101-003	4	48	0			
Part Specifications							
Specifications could not be found.							

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DART AEROSPACE LTD				Work Order: 196 972	
Description: 206 Saddle, Outboard, Left side				Part Number: D2665-1	
Inspection Dwg: D2665 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.121	.121	.120	
B	0.100	0.140		.130	.130	.130	.130	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		.653	.654	.652	.655	
E	0.240	0.260		.251	.251	.251	.252	
F	1.313	1.343		1.321	1.320	1.321	1.321	
G	0.210	0.230		.220	.220	.220	.220	
H	0.100	0.180		.135	.132	.134	.132	
I	2.470	2.510		2.492	2.495	2.495	2.495	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		.238	.238	.238	.238	
L	0.100	0.120		.115	.115	.115	.115	
M	0.990	1.010		1.004	1.002	1.002	1.00	
N	0.510	0.515		.510	.510	.510	.510	
O	5.990	6.010		5.998	5.998	5.998	5.998	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		.312	.312	.312	.312	
S	0.315	0.322		.316	.316	.316	.316	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		.794	.794	.794	.794	
W	0.540	0.560		.549	.550	.550	.549	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		.257	.258	.258	.258	
Z	0.912	0.932		.922	.922	.922	.921	
AA	0.490	0.510		.503	.503	.499	.502	
AB	0.178	0.198		.188	.188	.188	.188	
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 57	Date: 19/07/07
Audited by: 9-89 <i>[Signature]</i>	Date: 19/07/08
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension R and Y revised	KJ	<i>[Signature]</i>